

Work Order ID 61711

Tuesday, August 31, 2010 1:53:43 PM

Page 1

Item ID: D3793-3

Accept

Setup Start

Revision ID:

Item Name: Wearshoe

Stop

Start Date: 8/31/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-8-31 Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3793	Rev A								

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3793

Dwg Rev: A

Prog Rev: H

2-Deburr if necessary

304.040

B10-9-8

12

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B10-9-8

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/10/09/01

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1-Deburr if necessary

2-Form on Brake as per Dwg D3793 using Jigs

0.00

0.00

Sp 10/6/09

(12)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 10/6/09

(112)

150



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

DR 10-9-10

M 11/25/88

10:20
320°
10:50

(12)

W/O:		WORK ORDER CHANGES					
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Work Order ID 61711

Tuesday, August 31, 2010 1:53:43 PM



Page 3

Item ID: D3793-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 8/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 9/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

M 10/08/13

(12)

170



Packaging

Packaging

Identify as per dwg & Stock Location:

FP-18

0.00

Memo

0.00

BR 10-9-13.

12

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/14

BR 10-9-13
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, August 31, 2010 1:53:47 PM

Page 1

Work Order ID: 61711

Parent Item: D3793-3

Parent Item Name: Wearshoe





Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	111.7987	1.2828	13.50316	15.4		
											1810-7-8		

Location

Loc Qty

Loc Code

MAT 16.1522
114574 16.1522
MAT20 95.6465
112885 2.7475
113062 0.699
115440 92.2

115440

(12)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	61711
Description: Wearshoe		Part Number:	D3793-3
Inspection Dwg: D3793 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	.189	X		V 1B02	
0.300 x 0.300	+/-0.010	301 X 302	✓		V	
1.885	+/-0.010	1.890	✓		V	
4.389	+/-0.010	4.383	X		V	
6.547	+/-0.010	6.542	✓		V	
6.00	+/-0.030	6.000	✓		T 1B01	
6.75	+/-0.030	6.750	X		T	
2.000	+/-0.010	2.000	✓		V	
4.750	+/-0.010	4.750	✓		T	
9.500	+/-0.010	9.500	✓		T	
14.250	+/-0.010	14.250	✓		T	
17.750	+/-0.010	17.750	X		T	
26.735	+/-0.010	26.736	✓		T	
Ø0.531 x 0.780	+0.008/-0.001	.532 X .780	X		V	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-9-08	Date:	10/09/09	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.05.30	New Issue	KJ/DD	JD

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

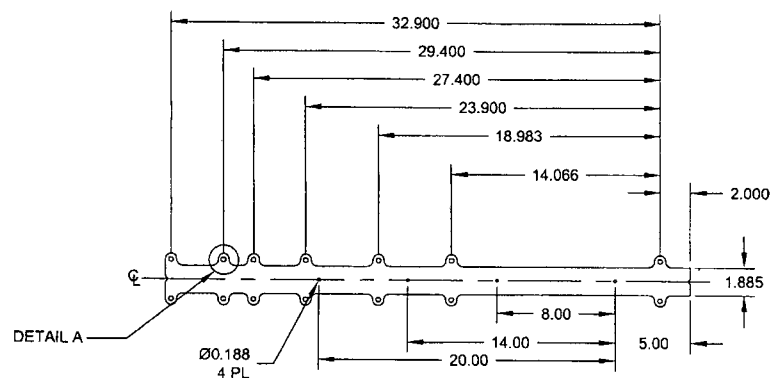
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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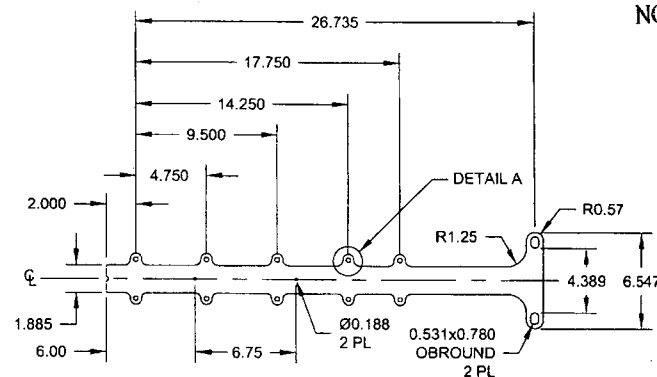
NOTE: Date & initial all entries

SHO.
RETURN TO
ENGINEERING

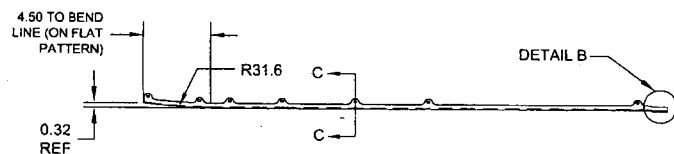
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60711
88-10-8-9



D3793-1F FLAT PATTERN



D3793-3F FLAT PATTERN



D3793-1 BEND DETAIL
(MAKE FROM D3793-1F)



D3793-3 BEND DETAIL
(MAKE FROM D3793-3F)

RELEASED
08.05.14

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" ON INSIDE SURFACE USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: D3793-1 - 0.72 LBS, D3793-3 - 0.66 LBS

A	NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA DRAWING NO. D3793 TITLE WEARSHOE		
DRAWN	PH			
CHECKED				REV. A
MFG. APPR.	DS			SHEET 1 OF 1
APPROVED	PH			SCALE
DE APPR.	PH			NT
DATE	08.05.14		COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

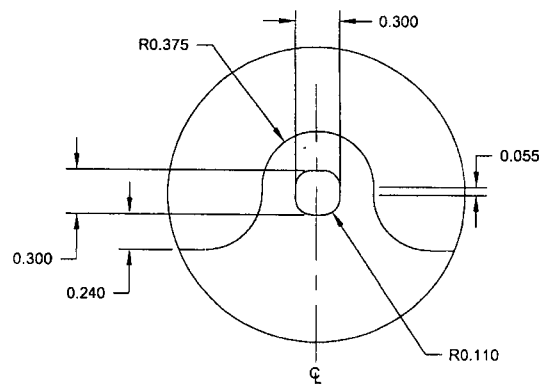
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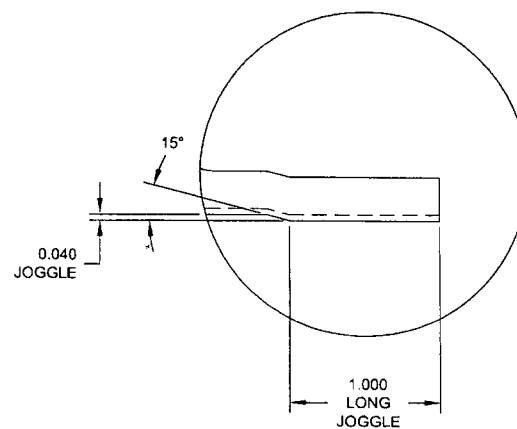
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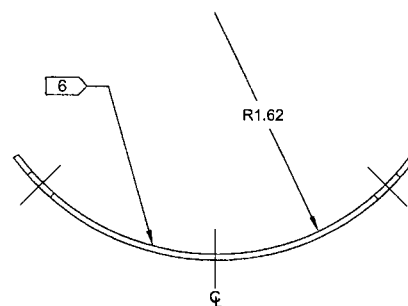
8 7 6 5 4 3 2 1



DETAIL A
SCALE 10X



DETAIL B
SCALE 10X



SECTION C-C
SCALE 10X

w/061711

RELEASED
08-05-14

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3793	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARSHOE	NTS
DATE	08.05.14	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

8 7 6 5 4 3 2 1

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